

Work Order ID 72569

Friday, July 29, 2011 1:34:48 PM

Page 1

Item ID: D4334-045

Accept

Revision ID:

Item Name: Boom Plate Assembly

Start Date: 7/29/2011 Start Qty: 1.00

Required Date: 8/2/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: ADate: 11-07-29 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4334

A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-Debur if necessary

B11-8-2

①

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 11/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72569

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Item ID: D4334-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Boom Plate Assembly

Start Date: 7/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
Small Fab	Memo	0.00							
Small Fab	1-C'sink as per dwg D4334								
127	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

SB 11/08/03

Suloblog

X1 d 11/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Revision ID:

Stop



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Start Date: 7/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

132



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

IX Ø m-14/08/03

135



Small Fab

Memo

0.00

0.00

Small Fab

Assemble as per dwg D4334

SS 4/6/08/04

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

8 4/6/08/04

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Setup Start



Revision ID:

Stop



Item Name: Boom Plate Assembly

Start Date: 7/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/01/04

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/08/04

11-08-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, July 29, 2011 1:34:54 PM

Work Order ID: 72569

Parent Item: D4334-045

Parent Item Name: Boom Plate Assembly

Start Date: 7/29/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.28 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21069L08		Purchased	No				Each	60.0000		6			
													
ANCHOR NUT													

Location Loc Qty Loc Code

MEZZ 60

102587 60

MS20426AD3-4		Purchased	No				Each	5,068.000		12			
													
RIVET													

Location Loc Qty Loc Code

ST316 5068

104374 1142

110398 3926

M2024T350.063"

0.178 sq ft

batch: 117389

B11-8-2 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

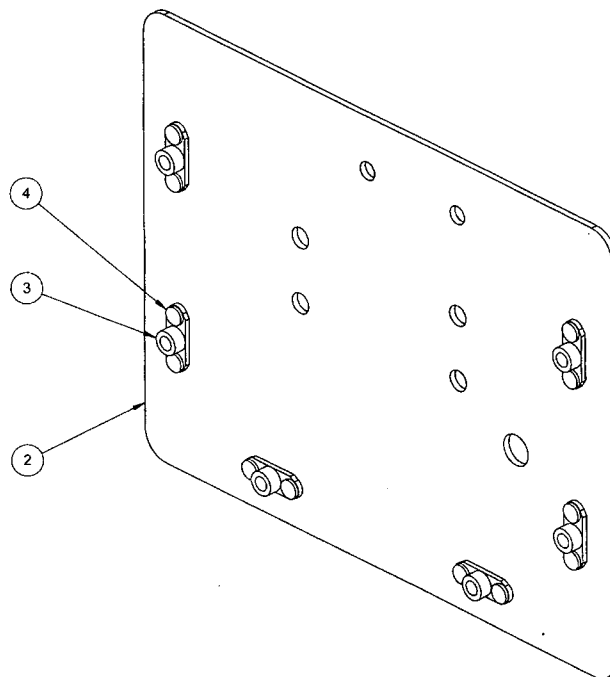
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4334-045	BOOM PLATE ASSEMBLY
2	1	D4334-11	BOOM PLATE
3	6	MS21069-08	NUTPLATE
4	12	MS20426AD3-A/R	RIVET



D4334-045 BOOM PLATE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72509

11-07-29

RELEASED
2011-05-27
M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	D4334	SHEET 3 OF 11
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
DATE	11.04.18	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

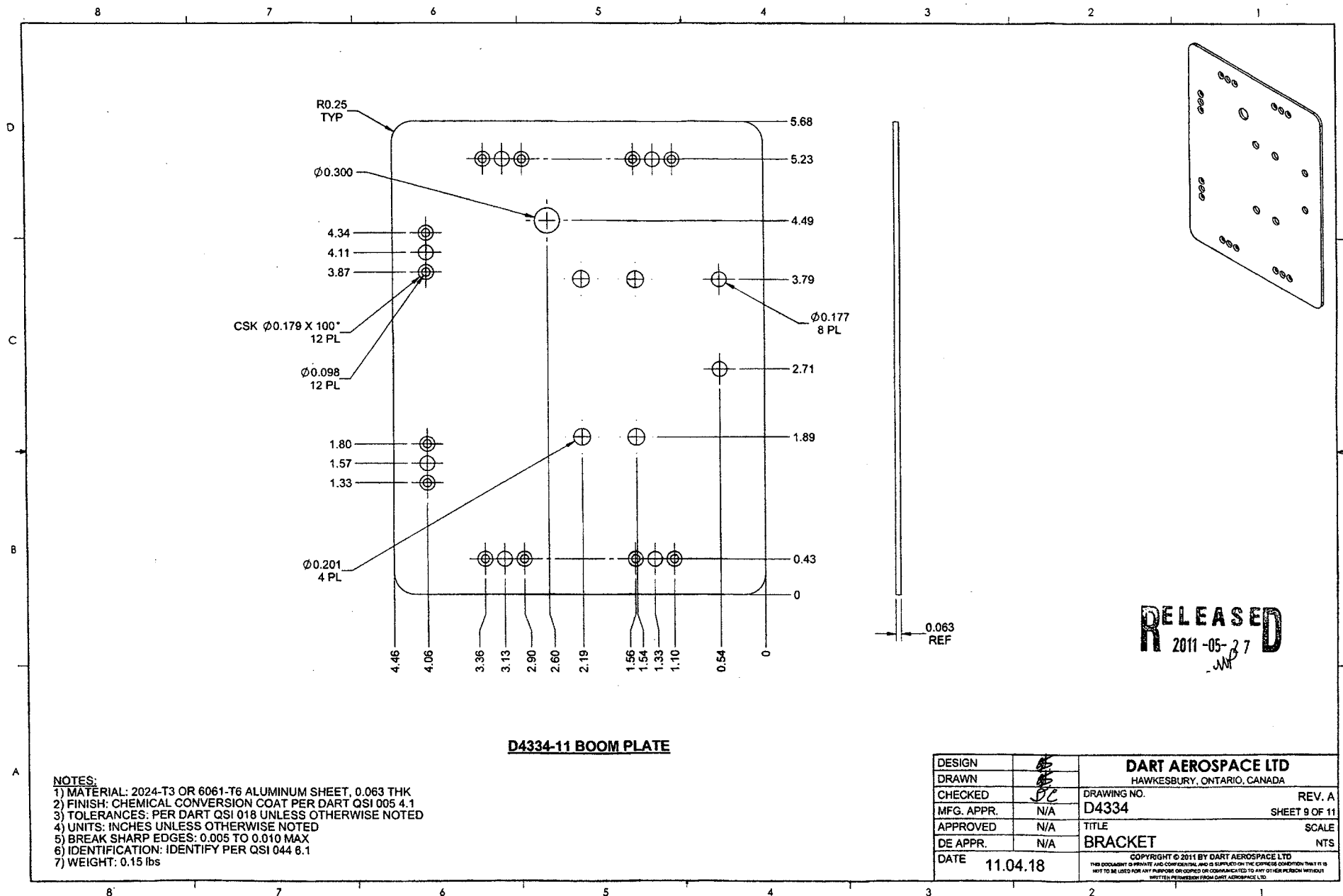
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	D4334	SHEET 9 OF 11
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DE APPR.	N/A	BRACKET	NTS
DATE	11.04.18	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DART AEROSPACE LTD	Work Order: 72569
Description: <u>Room PLATE ASSEMBLY</u>	Part Number: <u>D4334-045</u>
Inspection Dwg: <u>D4334-05</u> Rev: <u>A</u>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	✓		V B02	
Ø .177	+ .005 - .001	.177	✓		V	
Ø .201	+ .008 - .001	.200	✓		V	
Ø .300	+ .006 - .001	.300	✓		V	
.43	± .030	.431	✓		V	
1.89	± .030	1.885	✓		V	
2.71	± .030	2.711	✓		V	
3.79	± .030	3.791	✓		V	
4.49	± .030	4.489	✓		V	
5.23	± .030	5.233	✓		V	
5.68	± .030	5.684	✓		V	
.54	± .030	.543	✓		V	
1.10	± .030	1.102	✓		V	
1.33	± .030	1.331	✓		V	
1.54	± .030	1.541	✓		V	
1.56	± .030	1.563	✓		V	
2.19	± .030	2.194	✓		V	
2.60	± .030	2.602	✓		V	
2.90	± .030	2.898	✓		V	
3.13	± .030	3.134	✓		V	
3.36	± .030	3.368	✓		V	
4.06	± .030	4.061	✓		V	
4.46	± .030	4.466	✓		V	

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: _____
Date: <u>11-8-2</u>	Date: <u>11/08/03</u>	Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

